

Date: Tuesday, 11/21/2006 3:54:56 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARPLATE  
 Job Number : 29636  
 Estimate Number : 10606  
 P.O. Number : N/A Part Number : D33193  
 This Issue : 11/21/2006 S.O. No. : N/A Drawing Number : D3319 REV. B  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : SMALL /MED FAB Drawing Revision : B  
 Previous Run : 28813 Material : N/A  
 Due Date : N/A  
 Written By : JA 061121  
 Checked & Approved By : JA 061121  
 Comment : Est: A 05.05.12 New issue KJ/JLM  
 Est Rev: B Now on Waterjet 06-10-03 JLM

Qty: 7 Um: U

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S18GA 1010/1025/A21/6aA SHEET .048



Comment: Qty.: 3.4150 sf(s)/Unit Total: 20.4901 sf(s)

1010/1025/A21/6aA SHEET .048" Thick

Batch: M102287

ML 02 12 05

7

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3319

Dwg Rev: B

Prog Rev: B

ML 02 12 05

7

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 02 12 05

7

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Job 12-12

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary

18 Dec. 06

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 3:54:56 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29636

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 06/12/19

(7)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06/12/19 (7)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

M102885

UMF

06-12-28

(7)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

06/12/22 (7)

10.0

POWDER COATING

POWDER COATING



M101601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

m.R/ml

07/01/02

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



ml 07/01/02



(7)

Comment: INSPECT POWDER COAT

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST361

07/01/03 (7)

07/01/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/07/03  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 11/21/2006 3:54:57 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 29636

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



⑦

Comment: FINAL INSPECTION/W/O RELEASE

07/10/03

Job Completion



07/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

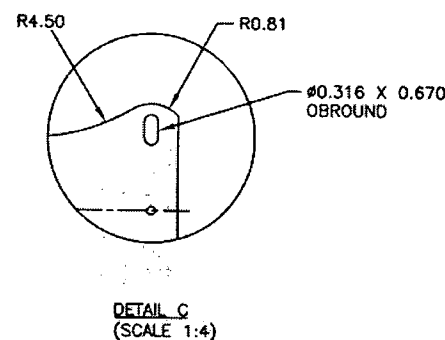
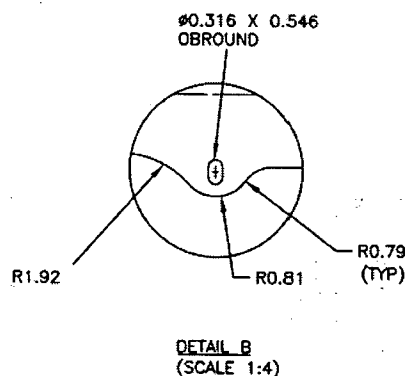
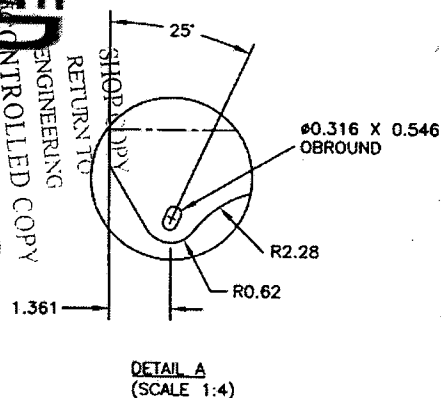
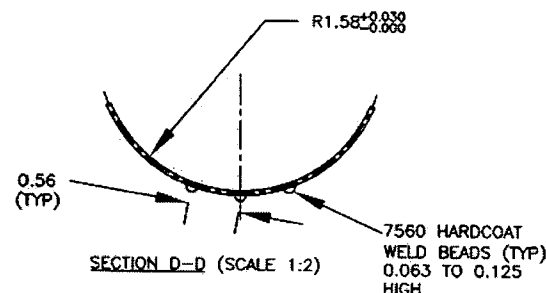
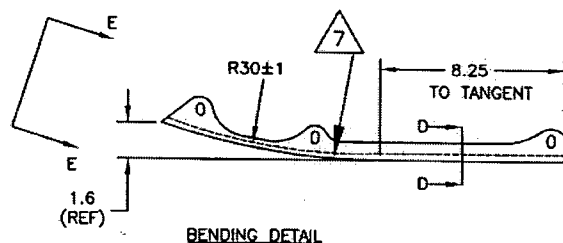
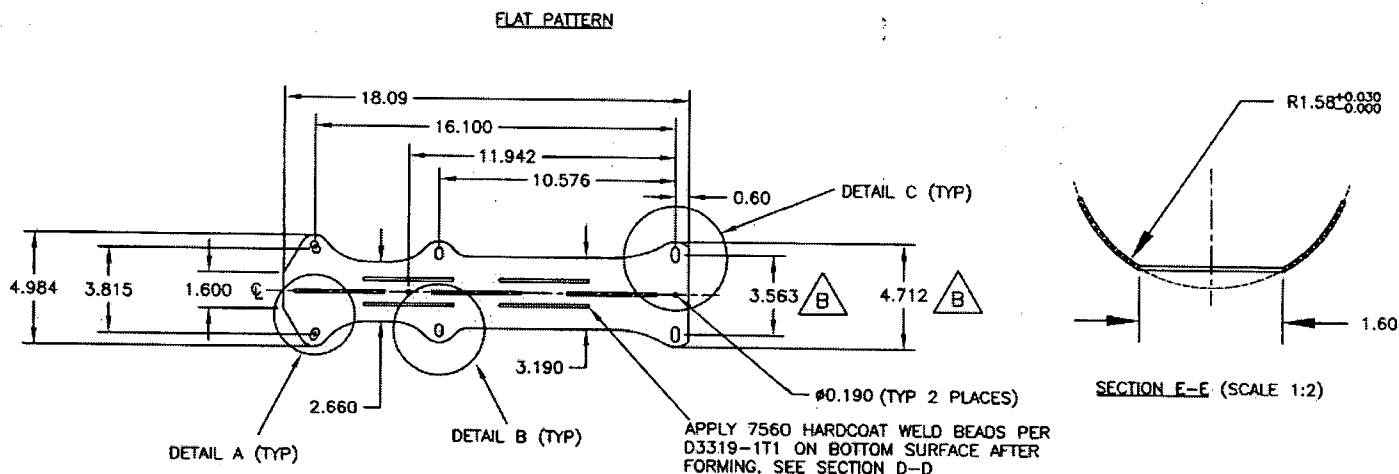
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**



**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXX, FOR PRODUCT ELIGIBILITY SEE: PDA05-18"

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.06.06	TITLE WEARPLATE	REV. B
		SHEET 1 OF 5
		SCALE 1:8
A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH -3/-5/-7

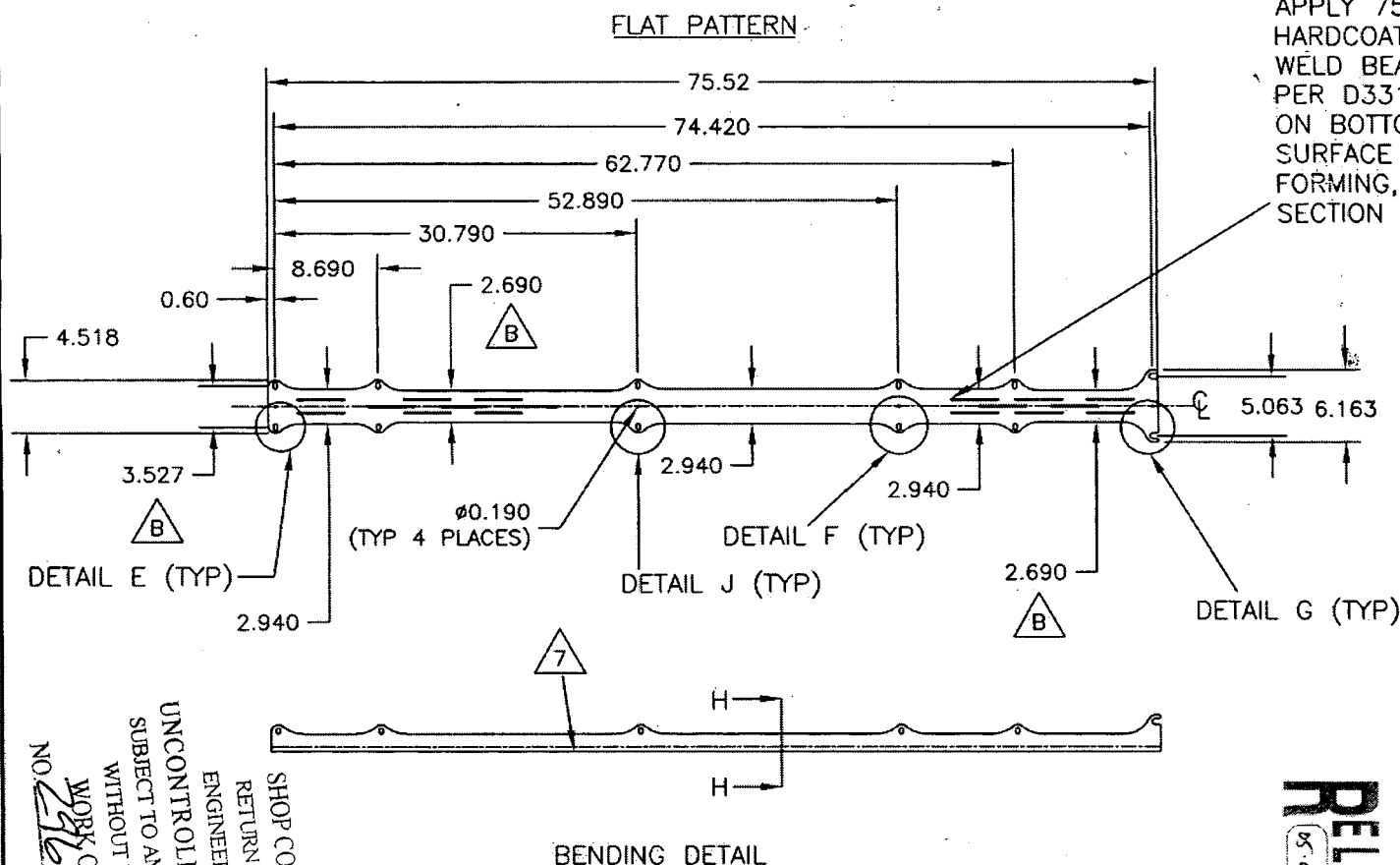
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05-09-30  
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WITHOUT NOTICE

WORK ORDER  
24636

**DART**

DESIGN	04	DRAWN BY	04	DART AEROSPACE LTD
CHECKED		APPROVED		HANKEBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 2 OF 5
				SCALE 1:15

APPLY 7560  
HARDCOAT  
WELD BEADS  
PER D3319-3T1  
ON BOTTOM  
SURFACE AFTER  
FORMING, SEE  
SECTION H-H



**RELEASED**  
05.07.30

# BENDING DETAIL

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WORK ORDER  
NO. 24636

## D3319-3 WEARPLATE

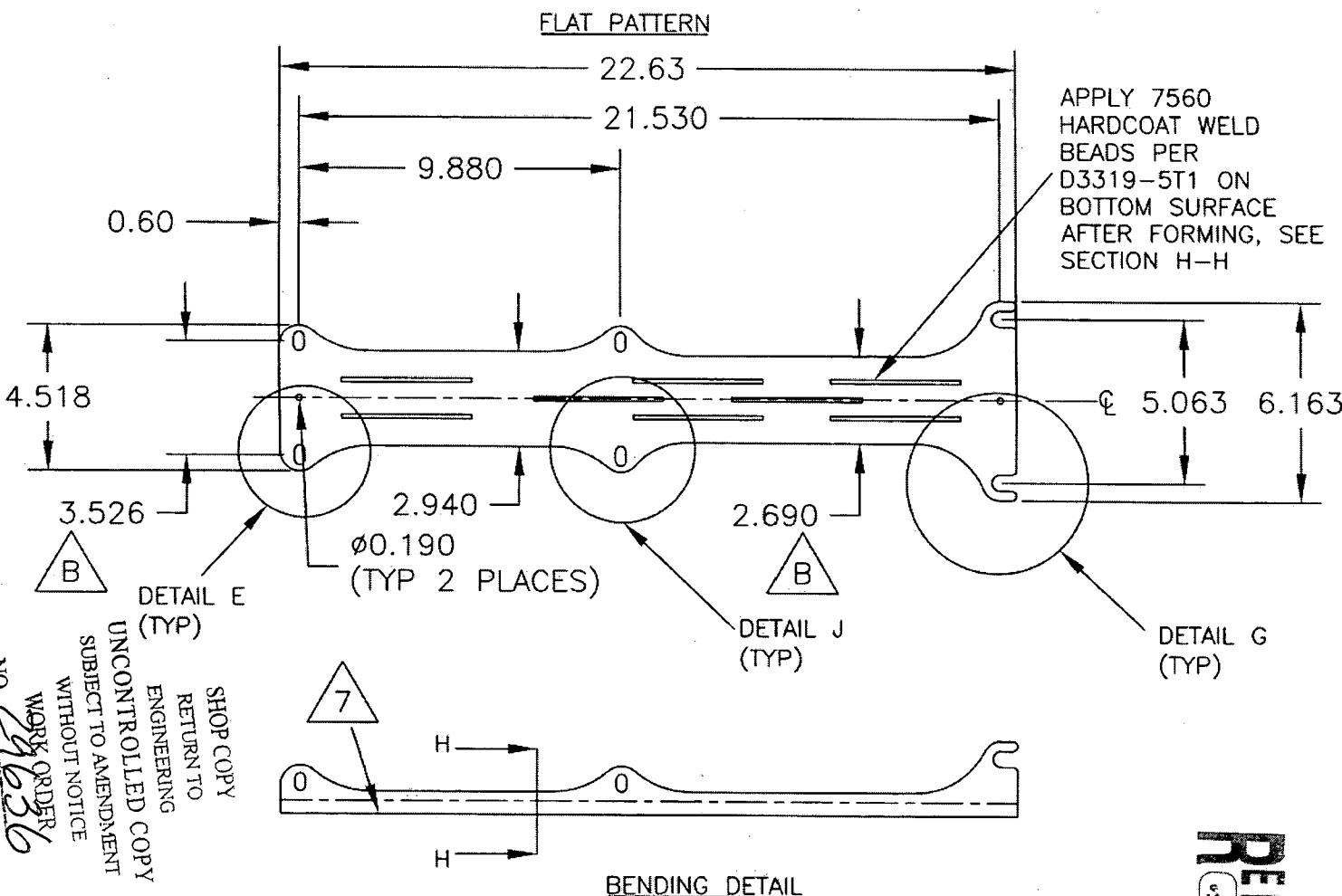
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"



**DART**

DESIGN	D41	DRAWN BY	D44	DART AEROSPACE LTD
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	TITLE	D3319	REV. B
		WEARPLATE		SHEET 3 OF 5
				SCALE 1:5

**RELEASED**  
05-07-30-11



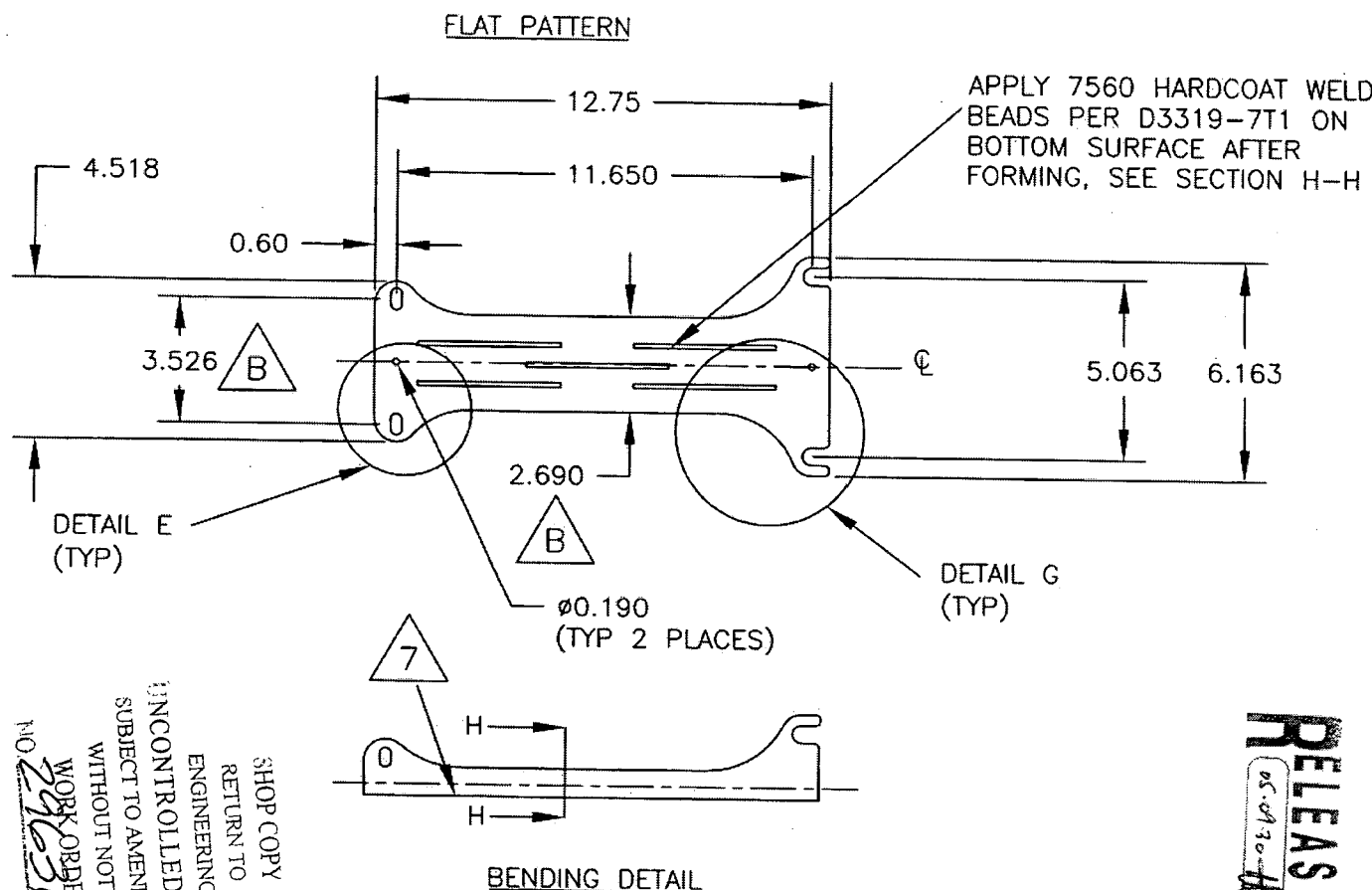
**D3319-5 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-5 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

**DART**

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CHECKED	PH	APPROVED	PH	DRAWING NO.	REV. B
DATE	05.06.06			D3319	SHEET 4 OF 5
				TITLE	SCALE
				WEARPLATE	1:5

**RELEASED**  
05.01.30-41



**D3319-7 WEARPLATE**

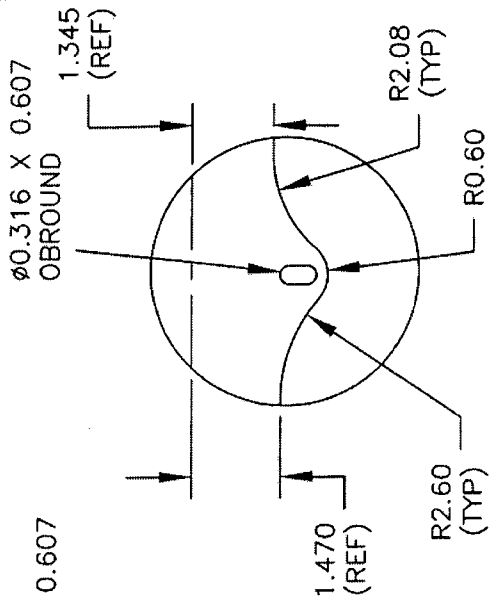
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,  
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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WORK ORDER  
NO. 24636

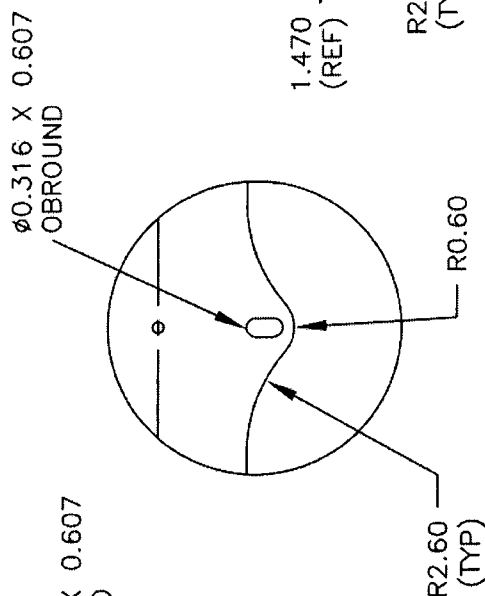


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

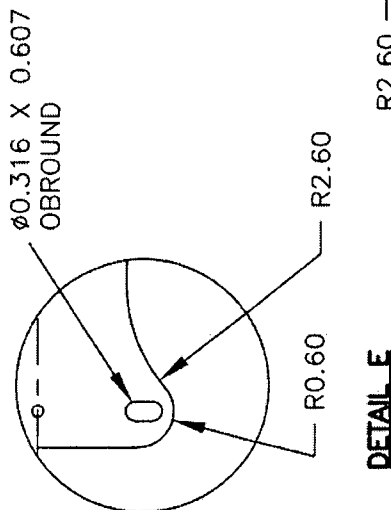
RELEASED  
05.09.30



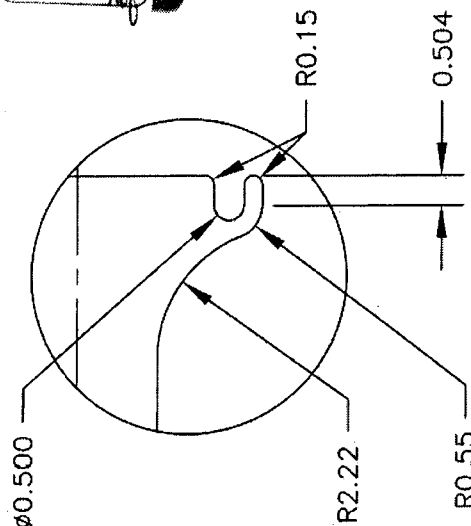
DETAIL J



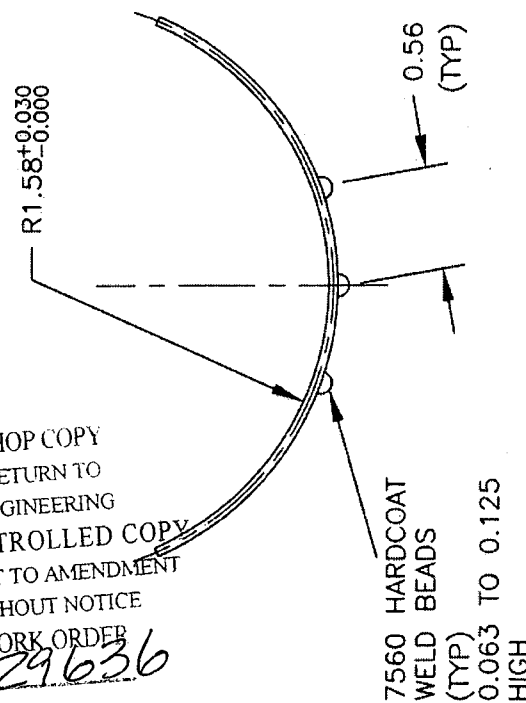
DETAIL F



DETAIL E



DETAIL G



SECTION H-H  
(SCALE 1:1)

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NO. 29636

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# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☒ Prototype

[illegible]

Measured by:	nat. nat
Date:	8/12/12

<b>Audited by:</b>	
<b>Date:</b>	08/12/12

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	